

IN THE CLAIMS:

1. (Currently Amended) A method for producing attached parts for a motor vehicle, including one or more of doors, dampers, mudguards, the method comprising:

providing an internal sheet and at least one external sheet with said sheets being produced separately from each other, said internal sheet having an outer surface;

5           bending the external sheet inwardly by up to 90° at sides visible from a position outside of said at least one external sheet in the edge area of an attached part to form a bent external sheet portion, said bent external sheet portion having an inner surface;

          pushing pertaining edge areas of the internal sheet, in a direction of said inner surface of said bent external sheet portion, against the [[bend]] bent external sheet portion of the at least one external sheet to minimize a gap defined between edge areas of said internal sheet and said [[bend]] bent external sheet portion of said external sheet, said internal sheet being moved relative to said external sheet, in said direction of said inner surface of said bent external sheet portion, to move at least a portion of said outer surface of said internal sheet into contact with at least a portion of said inner surface of said bent external sheet portion;

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15           welding the internal sheet and the external sheet together by a laser beam directed into the gap between the edge areas of the internal sheet and the bend of the external sheet;

          laying an open end of the external sheet and an open end of the internal sheet on each other in parallel to a component plane at one side at least or at all invisible sides in the edge area of the attached part lying opposite to the visible area(s), wherein said open end of the external sheet and said open end of the internal sheet extend in a direction parallel to the

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component plane, said open end of said external sheet having an inner external sheet surface,  
said open end of said internal sheet having an inner internal sheet surface, said inner external  
sheet surface engaging said inner internal sheet surface, wherein said inner internal sheet  
surface moves along said inner external sheet surface when said internal sheet is moved  
25 relative to said external sheet; and

laser-welding in an overlap joint of the open end of the external sheet and the open end  
of the internal sheet or laser-welded or laser-soldered in a fillet of the overlapping parallel  
edges of said open end of the external sheet and said open end of said internal sheet after said  
internal sheet is moved relative to said external sheet.

2. (Previously Presented) A method according to claim 1, wherein a visible edge area  
of said external sheet is inwardly bent at a sill side and/or lock side of a door for motor  
vehicles.

3. (Previously Presented) A method according to claim 1, wherein the invisible edge  
areas of a hinge side and/or of a window side of the door external sheet are connected with the  
edge areas of the door internal sheet in the overlap joint by laser welding or in the fillet of the  
overlapping edge areas by laser welding or laser soldering.

4. (Canceled)

5. (Previously Presented) A method according to claim 1, wherein in the visible area where the external sheet is inwardly bent, the internal sheet, too, is wholly or partly bent inwardly or outwardly in an edge area.

6. (Previously Presented) A method according to Claim 5, wherein the bend of the external sheet forms an acute angle to the bend of the internal sheet.

7. (Previously Presented) A method according to claim 1, wherein the edge areas of the internal sheet are inwardly or outwardly bent by up to 180°.

8. (Previously Presented) A method according to claim 1, wherein the edge area of the internal sheet is arranged in parallel to the external sheet and the edge of the internal sheet is so bevelled that said edge of said internal sheet forms an acute angle to the bend of the external sheet.

9. (Canceled)

10. (Currently Amended) A method for producing a motor vehicle part to be attached to a motor vehicle body, with the attached part having a visible edge area visible by a user of the motor vehicle and a hidden or not visible edge area that cannot be viewed by a user of the motor vehicle, the method comprising the steps of:

5 forming an internal sheet having an outer surface portion;

forming an external sheet produced separately from the internal sheet;

forming the visible edge area by bending the external sheet inwardly at a side by up to ninety degrees to form a bend and a bent portion, said visible edge area being visible from a position outside of said external sheet, said bent portion having an inner bent portion surface;

10 moving said internal sheet relative to said external sheet, in a direction of said inner bent portion surface, such that an edge area of said outer surface portion of the internal sheet is pushed against the inner bent portion surface to minimize a gap between the bent portion and the edge area of the internal sheet;

15 welding the internal sheet and the external sheet together by a laser beam directed into the gap between the edge area of the internal sheet and the bent portion adjacent to the bend of the external sheet after said internal sheet is moved in a direction of said bent portion, wherein said internal sheet and said external sheet define a component plane;

20 forming a hidden or not visible edge area by laying a flange end portion of the external sheet and a flange end portion of the internal sheet on each other to form overlapping flange end portions, at least a portion of said flange end portion of said external sheet being in direct contact with at least a portion of said flange end portion of said internal sheet, said hidden or not visible edge area not being visible from a position outside of said external sheet and said internal sheet, wherein said overlapping flange end portions extend in a direction parallel to said component plane; [[and]]

25 laser-welding the overlapping flange portions together after said internal sheet and said

external sheet are welded between the edge area and the bent portion and after said internal sheet is moved relative to said external sheet to form an overlap joint or laser-welding or laser-soldering in a fillet at overlapping flange portions to form an overlap joint, wherein at least a portion of said flange end portion of said internal sheet moves along at least a portion of said flange end portion of said external sheet when said edge area of said internal sheet is pushed against said bent portion of said external sheet.

11. (Previously Presented) A method according to claim 10, wherein the part is a motor vehicle door and the visible edge area of the external sheet is inwardly bent at a sill side and/or lock side of the door.

12. (Previously Presented) A method according to claim 11, wherein the not visible edge area is at a hinge side and/or a window side of the door external sheet.

13. (Canceled)

14. (Previously Presented) A method according to claim 10, wherein the bend of the external sheet forms the bent portion at an acute angle to the internal sheet.

15. (Previously Presented) A method according to claim 10, wherein the edge areas of the internal sheet are inwardly or outwardly bent by up to 180°.

16. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is provided by bending an end in a direction away from the external sheet.

17. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is provided by bending an end in a direction toward the external sheet.

18. (Previously Presented) A method according to claim 10, wherein the edge area of the internal sheet is the end face of the internal sheet directed toward an inner surface of the bent portion of the external sheet.

19. (Currently Amended) A motor vehicle part to be attached to a motor vehicle body, comprising:

an external sheet comprising a visible edge area visible by a user of the motor vehicle, said external sheet being visible from a position outside said external sheet, wherein a side of said visible edge area of said external sheet is bent by an angle up to ninety degrees to form a bend and a bent portion, said bent portion having an inner surface; and

an internal sheet comprising an outer surface and a hidden or not visible edge area that cannot be viewed by a user of the motor vehicle, said hidden or not visible edge area not being visible from a position outside of said external sheet and said internal sheet, said internal sheet and said external sheet defining a component plane, said internal sheet being produced separately from said external sheet, wherein said internal sheet is movable relative

to said external sheet such that an edge area of said internal sheet is pushed in a direction of  
said inner surface of said bent portion in a non-welded state of said internal sheet and said  
external sheet ~~against the bent portion the external sheet~~ to minimize a gap between the bent  
15 portion and the edge area of the internal sheet, wherein said inner surface of said bent portion  
engages at least a portion of said outer surface of said internal sheet, the internal sheet and the  
external sheet being welded together by a laser beam directed into the gap between the edge  
area of the internal sheet and the bent portion adjacent to the bend of the external sheet with  
said edge area of said internal sheet pushed against the bent portion, wherein the hidden or not  
20 visible edge area is an open flange end portion of the external sheet in contact with an open  
flange end portion of the internal sheet, said open flange end portion of said external sheet  
being movable along said open flange end portion of said internal sheet in said non-welded  
state, said open flange end portion of said external sheet and said open flange end portion of  
said internal sheet extending in a direction parallel to said component plane to form  
25 overlapping flange end portions, wherein the overlapping flange end portions are laser-welded  
together to form an overlap joint or laser-welded or laser-soldered fillet at the overlapping  
flange portions to form an overlap joint, wherein said overlap joint is formed after said edge  
area of the internal sheet is welded to said bent portion of said external sheet.

20. (Previously Presented) A motor vehicle part according to claim 19, wherein the  
part is a motor vehicle door and the visible edge area of the external sheet is inwardly bent at  
a sill side and/or lock side of the door and the not visible edge area is at a hinge side and/or a

window side of the door external sheet.

21. (Previously Presented) A motor vehicle part according to claim 19, wherein the edge area of the internal sheet is provided by bending an end in a direction away from the external sheet or in a direction toward the external sheet.

22. (Previously Presented) A method according to claim 1, wherein said internal sheet is slidable against said external sheet in said component plane.

23. (Currently Amended) A motor vehicle part according to claim 19, wherein said flange end portion of said internal sheet ~~and said flange end portion of said external sheet are movable with respect to one another with said gap in an unwelded state~~ is moved in a direction of said bent portion of said external sheet.